

Date: Monday, 2/11/2008 2:15:04 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001: Dart Helicopters Services			Drawing Name	: FUEL PURGE CANISTER		
Job Number	37369A			Part Number	: D32621		
Estimate Number	10441			Drawing Number	: D3262 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	2/11/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	:/	Type	MACHINED PARTS	Due Date	2/28/2008	Qty:	5
Previous Run	: 36777A			Um:	Each		
Written By	:						
Checked & Approved By	:						
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K JJLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T5000W125	6061-T6 Tube 5.00X.125W	
Comment: Qty.: 0.9406 f(s)/Unit Total : 4.7030 f(s) Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125) Identify as D3262-1 Batch: 105532			
2.0	BAND SAW	BAND SAW	
Comment: BAND SAW Cut D3262-1 to length as per Dwg D3262 Identify as D3262-1			
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 37369A		Part Number: D32621
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST163 <i>2008/02/15</i> ⑤		
7.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE <i>2008/02/22</i> ⑤		
Job Completion  <i>2008/2/19</i> ⑤ 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<u>37369A</u>
Description: Tube	Part Number:	<u>D3262-1</u>
Inspection Dwg: D3262 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <i>RQ</i>	Audited by: <i>J.L.</i>	Prototype Approval: N/A
Date: <i>08/02/15</i>	Date: <i>08/02/15</i>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue	KJ/JLM	
B	06.12.14	Dwg updated to Rev. C	KJ/JLM	EE

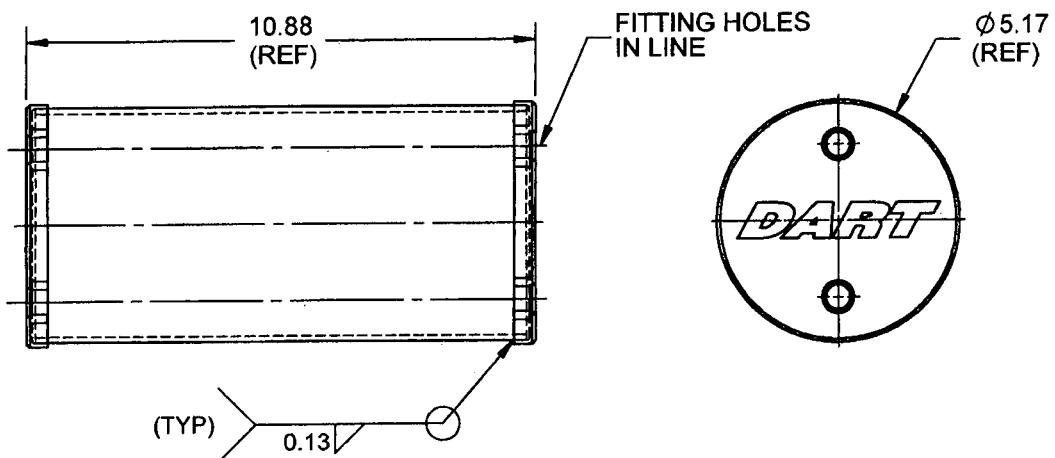
DART

DESIGN <i>RF</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D3262 REV. C SHEET 1 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER SCALE 1:4

REV	DATE	DESCRIPTION
A	04.05.06	FIRST ISSUE
B	05.02.14	ADD PRESSURE TESTING OPTION
C	06.08.31	Ø 5.165 WAS Ø 5.190

RELEASED

06.09.19 *TH*

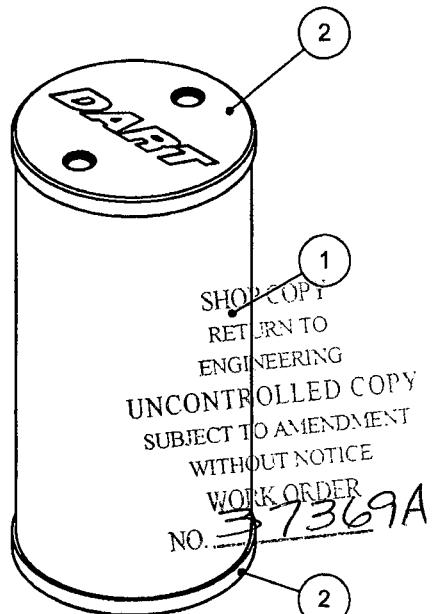


D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

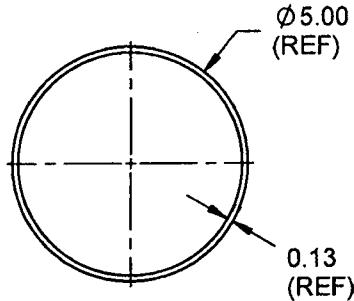
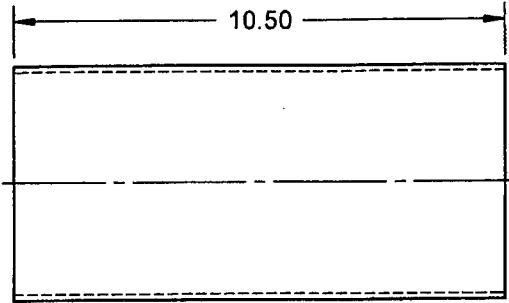
NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO Δ B
CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART
QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



DART

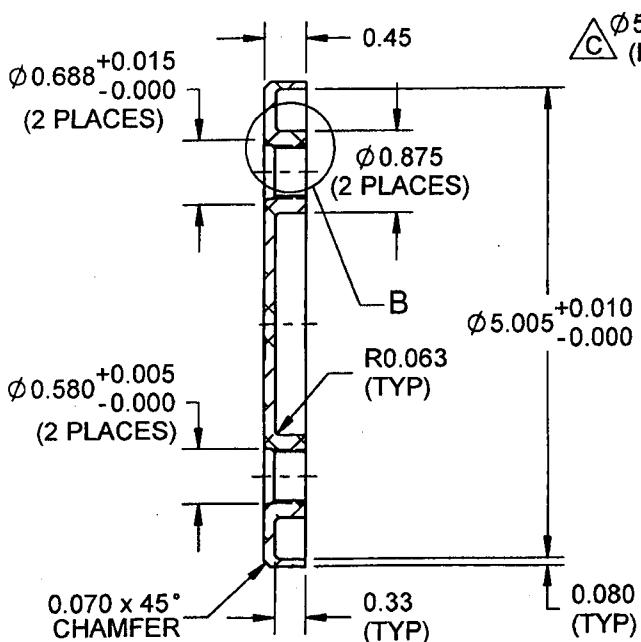
DESIGN <i>RF</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>AA</i>	DRAWING NO. D3262	REV. C	SHEET 2 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER	SCALE 1:4	



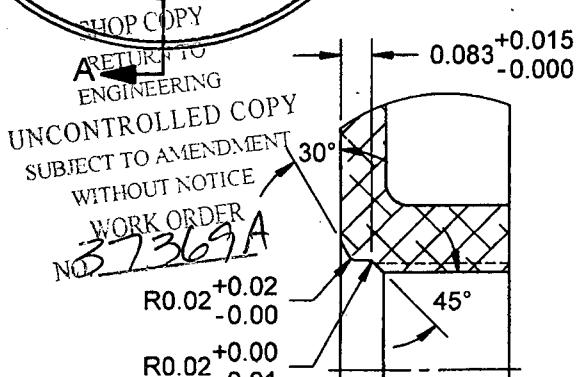
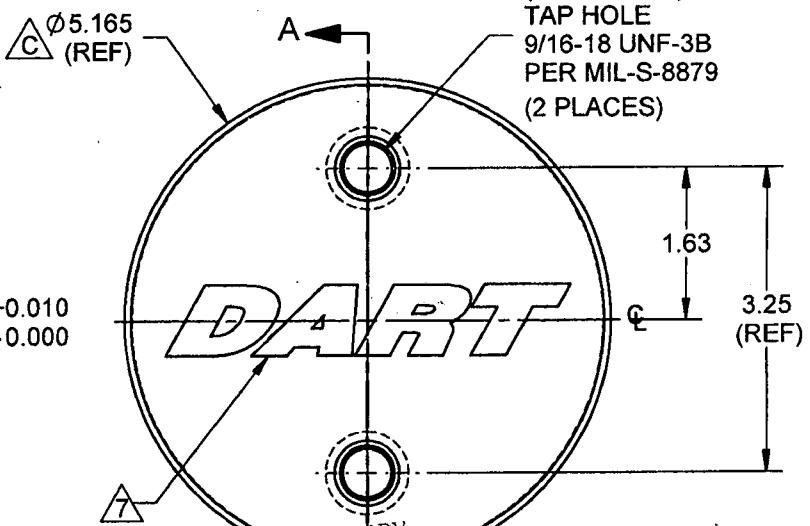
RELEASED
06.09.04

D3262-1 TUBE

1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)



SECTION A-A
SCALE 1:2



DETAIL B
SCALE 2:1

D3262-3 CAP

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)